



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP1425-105-03
Job Sheet 189673



Part No: RBBP1425-105-03

Job Qty: 50 pcs

Part Name: Keeper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	50 pcs	2/1/19	2/1/19	0.00	5.00	Waterjet - Omax	DL 19/03/05
110	SL-2500Y - B4B	50 pcs	2/1/19	2/1/19	0.00	25.00	SL-2500Y - 1 - B4B	DL
120	QC 2	50 pcs	2/1/19	2/1/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	DL
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	



Container No: S159490



Part: RBBP1425 - 105 - 03

Job No: 189673

Serial No/Batch: S159490

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/02/19

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				QC 2 - 63	
				QC 2 - 8	
130 NV5000 - 1 - B4B	50 pcs	2/1/19	0.00 12.50	NV5000 - 1 - B4B	PJ / Justin 19-03-21
				NV5000 - 2 - B4B	
140 QC 2	50 pcs	2/1/19	0.00 0.00	QC 2 - 1	PJ / Justin 19-03-21
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 38	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
150 QC 8	50 pcs	2/1/19	0.00 0.00	QC 8 - 12	PJ / Justin 19-03-21
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
180 Outsource - 12 - Black Oxide	50 pcs	2/1/19		GRO002-VC	5 03/22/2019 JL
200 Packaging 2-1 - Receive - B4B	50 pcs	2/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	

APR 02 2019

					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
210	QC 6	50 pcs	2/1/19	0.00 0.00	QC 6 - 38	
					QC 6 - 42	
					QC 6 - 9	DAS
					QC 6 - 68	APR 02 2019 68
					QC 6 - 61	9-89
215	Packaging 3-1 - Stock - B4B	50 pcs	2/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS
					Packaging 3 - 8 - B4B	28
					Packaging 3 - 9 - B4B	9-89
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

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					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
220 QC 21 - SA	50 pcs	2/1/19	0.00	0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-88

APR 03 2019

Part Op 100 - OMAX (Waterjet 2) Cut blanks (RED BARN FOLDER) ***Note***makes four pieces***
 Descriptions: 110 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per folio FC026 FOLIO REV: AA DWG REV: D 2-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC026 FOLIO REV: AA DWG REV: D ***Note***makes four pieces*** 2-Deburr 3-Machine engrave as per note 6
 140 - (QC2- Inspect parts off machine FAI/FAIB)
 150 - (QC8- Inspect parts - second check)
 180 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
 200 - (Receive & Inspect for Damage & Mat'l Certs)
 210 - (QC6- All purchased or subcontracted products)
 215 - (Identify as per dwg & Stock Location: _____)
 220 - (QC21- Final Inspection - Work Order Release)

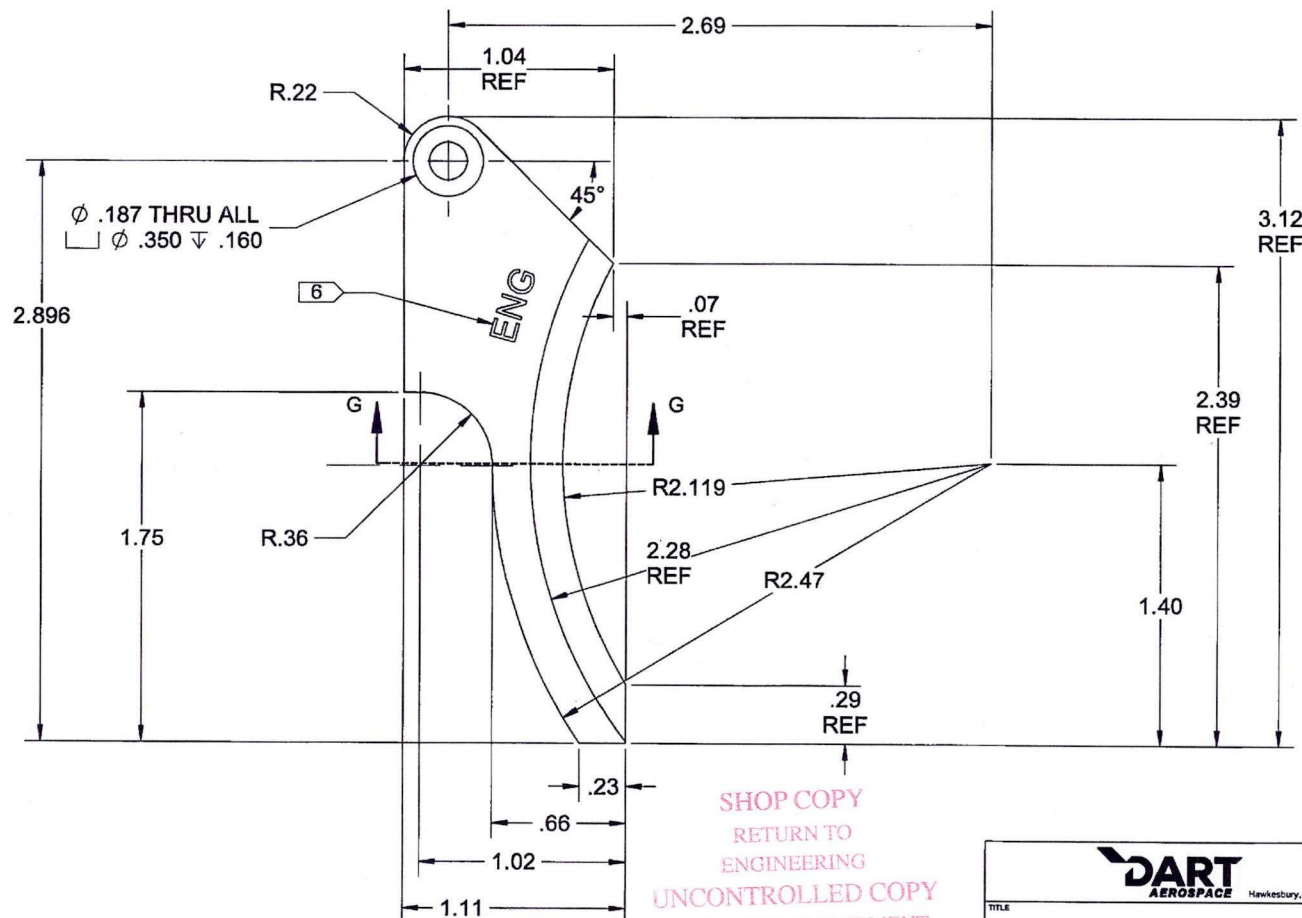
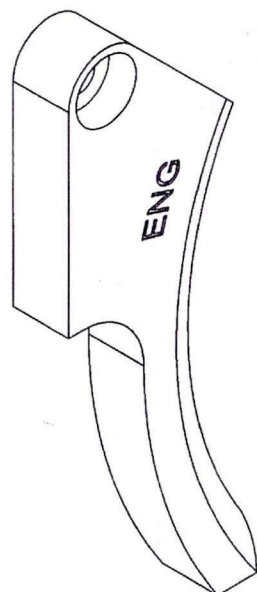
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AISI 4140 Steel Sheet/Plate	27 ft (.54 ea)	100-Waterjet - Omax - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-4140-S-0.500X10.000	27	9	0

Part Specifications
Specifications could not be found.

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REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
C	TEMPLATE UPDATED, MATERIAL 4140/4142 CHANGED FOR 17-4 PH / H900, FINISH REMOVED, VIEWS CHANGED FOR CLARITY, NOTE 7 ADDED	17-647	18.1.3	VM	ML



RBBP1425-105-03 KEEPER

NOTES:

- 1) MATERIAL: 17-4 PH SS / H900 OR 4140/4142 (Rc 28-32)
- 2) FINISH: IF MANUFACTURED FROM 17-4PH-H900: N/A
IF MANUFACTURED FROM 4140/4142 : BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4
THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN AND FILL WITH BLACK INK, 0.010" DEPTH
- 7) REFER TO CAD MODEL FOR ALL NON DIMENSIONED FEATURES



SECTION G-G

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1890734W
1901-29

		Hawkesbury, Ontario, Canada	
		KEEPER	
PART NO.		RBBP1425-105-03	
TOOL NO.		RBBP1425-105	
INITIALS AND DATE		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	VM 1/23/2018	TOLERANCES:	FRACTIONS ± 1/8
DRAWN BY:	ML 03/20/2018	XXX ± .005	ANGLES ± .5°
CHECKED BY:	ML 03/20/2018	XX ± .01	SURFACE
MTG REVIEW BY:	DP 03/20/2018	X ± .1	ROUGHNESS
APPROVED BY:	ML 03/26/2018	SCALE: NTS	SHEET 11 OF 12
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S159490



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Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1278 Aberdeen Street
Hawkesbury, ON K64 1K7
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TEL: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/06/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042962



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042962

PO Date: 3/22/19

Due Date: 3/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186406	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	3/29/19	8 pcs	0 pcs	8 pcs	\$1.50/pcs	\$12.00
8x APR 02 2019											
Line Item Note ** NEED BACK MARCH 29,2019 **											
2	189673	RBBP1425-105-03	Keeper (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	3/29/19	48 pcs	0 pcs	48 pcs	\$2.89/pcs	\$138.72
48x APR 02 2019 DAS 68 9-89											
Line Item Note ** NEED BACK MARCH 29,2019 **											
Grand Total:										\$150.72	



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042962



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/25/19 3:28 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017924- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
01-Apr-2019		Shankar Anand		042962 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-2706-00-07 ✓ Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8 ✓	0	0	0
2	RBBP1425-105-3 ✓ Rev.	RBBP1425-105-3 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	48	48 ✓	0	0	0

DAS
68
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.